Work Ord Thursday, Augus					*6	8946	31*							Page 1
Item ID: Revision ID: Item Name:	D350-567-03 Interior Floor V	1 Window (Sliding Door	Compatible	e)	Accept		*N900	1 040	100)*	Setup	Start Stop	IV	S1* S2*
Start Date: Required Date: Reference:	8/23/2012 8/23/2012	Start Qty: 1.00 Req'd Qty: 1.00		*1* *1*			Cust Item Customer						1 4	(1/
Approvals:	Process Plan	n: MY	Date:	12-08.5	プTooling: SPC (Y/			Date:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II Draw Nbr)	Operation Description sion Nbr			Set Uţ Run H		Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
N/A	Rev 1												•	
*100 *100* DC Document Control		DOCUMENT CONTRO Memo Photocopy b		create labels p	0.00 0.00 er PPP D350-56	AS 16 67-031 chg00	17/08/24				M	W	12,	102123
*110 *110* Packaging Packaging		Packaging Memo Pick Packing ***ENSURE		EMPLATE IS	0.00 0.00 INCLUDED**	**							<u>/</u> .	2/8/201

120

120

Quality Control

QC4- 100% Inspect kits for completeness

Memo

				DQA:	Date:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		 	

									QA Closed:	Date:	
Work Ord	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part I	No				Rework Scrap Use-as-is Work Order Update	- 1	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	1 .		Ĭ .	Descri	ption of work order update	Initial	Ad	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											
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Operator						1					
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Landi	ng Gear				General				1		-
	Bendin	_			Bend	Grain			Ovalized	_	Pressure/Forced
		Not Conce	ntric to	o/s _	BOM/Route	Hardwa			Over/Under	 	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged		ion Incomplete		Part Incorred	 	Weld
		d/Crimped		<u> </u>	Burrs	 -	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte			Part Moved		
	Heat T			<u></u>	Countersink	Mislabe			Positioned V		7 :
		ion Strip in	Tube		Cut Too Short	Misread	d	L	Power Loss/	Surge	Other
	Ripples in Bend Drill Holes				Offset						
e	· ·	Waves in I		n	Drawing		Calibration				
y.		g Sequence			Finish	\vdash	Sequence				
	Wave/	Twist in Tul	oe e		Folio	Outside	Dimensions				

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89461

Page 2

Thursday, August 23, 2012 11:14:25 AM Item ID: D350-567-031 Accept *N900040100* Setup Start Revision ID: Item Name: Interior Floor Window (Sliding Door Compatible) **Start Date:** 8/23/2012 Start Qty: 1.00 **Cust Item ID:** Required Date: 8/23/2012 Req'd Qty: 1.00 *1* **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 130 0.00 Packaging *130* Packaging 0.00 Packaging Identify and pack for shipping as per PPP D350-567-031 Location: PPP Rev:____ 140 QC21- Final Inspection - Work Order Release 0.00 MC 12/08/24 *140* QC 0.00 Memo Quality Control

			DQA:	Date:	
JCR.	Ves / No	WORK ORDER NON-CONFORMANCE / UPDATE		 	

									QA Closed:	Date:	
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	No.				Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root]		Descri	ption of work order update	Initial	Α	Action	Sign &	1	
Cause	Date	Step	Qty	1	or Non-conformance	Chief Eng	Des	scription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling						į					\
Operator											
Material											
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Other											
Process											
Supplier											
Training											<u> </u>
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						AULT CAT	EGORY				
Landir I	ng Gear				General	п .		Γ-	1		7_
	Bending			_,_ -	Bend	Grain			Ovalized	. ,	Pressure/Forced
	Centre N	ot Concei	ntric to	^{0/S} -	BOM/Route	Hardw		-	Over/Under		Temperature/Cure
	Cracks	/C.:			Broken/Damaged		tion Incomplete	-///	Part Incorre		Weld
	Crushed/	Crimpea.		-	Burrs	\vdash	ctions Incomplete enance	Unclear	Part Lost/M Part Moved	issing	Wrong Stock Pulled
	Cuffs Heat Trea	-4		-	Contamination Countersink	Mislab		-	Positioned V	Mrana	
	Inspectio		Tubo	-	Cut Too Short	Misrea	,		Power Loss/		Other
·	Ripples in	•	iuse	 	Drill Holes	Offset		<u>L.</u>	Ti owei ross/	Juige	Totalei
ŀ	—		vtrucio	,	Drawing		Calibration			<u> </u>	
ę,	Torque Waves in Extrusion Turning Sequence			` 	Finish	\blacksquare	Sequence				
	Wave/Tw				Folio		e Dimensions				

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120

Loc Qty

Each

9.0000

Loc Code

No

Location

79310 81495

ST211

Manufactured

		DQA:	Date:	
NCD: Voc / No	MORK ORDER NON-CONFORMANCE / LIDDATE			

									QA Closed:	Date	
Work Ord	or.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part I	No				Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descr	iption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling											
Operator Material			,								
Setup	*										
Other .				*							•
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	Bending		•		Bend	Grain			Ovalized		Pressure/Forced
	Centre N	ot Concer	ntric to (o/s	_BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Instruc	tions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maint	enance		Part Moved		
	Heat Tre	at		<u> </u>	Countersink	Mislab	eled		Positioned V	Vrong	_
	Inspection	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Offset					
	Torque V	Vaves in E	xtrusion	٦ _	Drawing	Out of	Calibration				
, [Turning S	Sequence			Finish	Out of	Sequence				
	Wave/Tw	vist in Tüb	e e		Folio	Outsid	e Dimensions			<u>.</u>	

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₽Thursday, August 23, 2012 11:14:24 AM

Work Order ID: 89461 Parent Item: D350-567-031 Required Date: 8/23/2012 **Start Date:** 8/23/2012 Interior Floor Window (Sliding Door Compatible) Parent Item Name: Start Qty: 1.00 Required Qty: 1.00 D3212-1-120 Each 13.0000 Manufactured Floor Window Location Loc Qty Loc Code ST210 13 79307 6 81496 D3213-041 Manufactured No 120 Each 5.0000 Door Assembly Location Loc Qty Loc Code ST211 81494 DT8439 120 Manufactured No Each 0.0000 template No 120 Purchased Each 2,424.0000 Rivet, Universal Head Location Loc Qty Loc Code 334 1500 122452 1500 ST319 924 118405 349 575 120142 No 120 Purchased Each 3,130.0000 Rivet, Universal Head Location Loc Qty Loc Code 336 1500 122452 1500 ST319 1630 117395 16 118927 157 119109 12 120142 81 121524 1364

									DQA:	Date:	
NCR: \	Yes / No				WORK ORDER NON-C	CONF	ORN	MANCE / UPDATE	QA Closed:	Date:	
Work Orde	or:		· · · · · · · · · · · · · · · · · · ·		DISPOSITION			AGAINST D	EPARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is Work Order Update] 7	N Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Init	tial	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	f Eng	Description	Date -	Verification	QC Inspector
Doc/Data									*		
Equip/Tooling							İ		·,		
Operator											
Material				ł							i di wa
Setup											
Other										*	·
Process		1									
Supplier											
Training			ľ								
Unapproved						<u> </u>					
					F	AULT (CATE	GORY			
Landin	ng Gear				General				_	·	•
]	Bending				Bend	Gr	rain	<u>L</u>	Ovalized	<u></u>	Pressure/Forced
	Centre N	ot Concer	ntric to	o/s	BOM/Route	Ha	ardwar	re	Over/Under	tolerance	Temperature/Cure
ļ	Cracks				Broken/Damaged	—	· ·	on incomplete	Part Incorred	ct	Weld
Ļ	Crushed/	Crimped.			Burrs	Ins	structi	ons Incomplete/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Ţ	Cuffs				Contamination	Шм	ainte	nance	Part Moved		
į	Heat Trea	et		1	Countersink	Mi	islabel	led	Positioned W	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

J Thursday, August 23, 2012 11:14:24 AM Work Order ID: 89461 Parent Item: D350-567-031 **Start Date: 8/23/2012** Required Date: 8/23/2012 Interior Floor Window (Sliding Door Compatible) <u>Parent Item Name:</u> Start Qty: 1.00 Required Qty: 1.00 MS20470AD4-7 Purchased No 120 Each 2,021.0000 20 Rivet, Universal Head Loc Code Location Loc Qty 336 1300 122452 1300 ST139 404 20 121415 404 ST319 52 120769 52 ST320 265 116081 117 118614 148 No 120 Purchased Each 559.0000 Location Loc Qty Loc Code 315 282 122441 282 ST300 77 121556 77 ST317 200 122151 200 NAS1149DN632J No 120 Purchased Each 306.0000 Washer Location Loc Qty Loc Code 298 200 122441 200

106

106

ST298

118428

											DQA:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-	·CO	NFORM	MANCE / UP	DATE	QA Closed:	Date:	
[T		1		· · · · · · · · · · · · · · · · · · ·	QA Closed.	Date.	
Work Ord	er.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	,
Work Ora	-					Rework	7		Skid-tube	Crosstube	7	Water Jet	Engineering
Part	No.					Sċrap	7		Machining	Small Fab	-4	d. Eng. Coor.	Quality
	_					Use-as-is	7	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No		· · · · · · · · · · · · · · · · · · ·	<u> </u>		Work Order Update			Large Fab	Composite]	Supplier	
Root					Descri	ption of work order update	T	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ш										•		
Equip/Tooling												·	
Operator						e •							
Material													
Setup	Ш						1						
Other							1						
Process							1						
Supplier							1						
Training			·			•							
Unapproved			İ										<u></u>
							FAUL	T CATE	GORY				<u> </u>
Landi					_	General		,			_		
	L	Bending				Bend	L	Grain		L	Ovalized		Pressure/Forced
	Ш	Centre No	ot Concer	ntric to (o/s	BOM/Route •		Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
	-	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped				Burrs		Instructi	ons Incomplete/	Unclear	Part Lost/M	ssing	Wrong Stock Pulled	
	Cuffs					Contamination		Mainte	nance		Part Moved		
	Heat Treat					Countersink		Mislabe	led		Positioned V	Vrong	_
	Inspection Strip in Tube					Cut Too Short		Misread			Power Loss/	Surge	Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

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5.0 **PARTS LIST**

Qty	Qty	Qty	Qty	Qty	Qty		
-015	-017	-025	-027	-111	-117	Part Number	Description
Х	-					D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	Х					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			Х			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				Х		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					Х	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
		ļ					
1	1			i		D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT
							(SLIDING DOOR COMPATABLE)

				7-		
Qty	Qty	Qty	Qty	/Qty /		
-013	-023	-113	-115	2031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				\\	D350-567-031	INTERIOR FLOOR WINDOW KIT
			1			(SLIDING DOOR COMPATABLE)
				91	20105	DEDI AGENENT WINDOW OMALL
1				- !! -	D2125	REPLACEMENT WINDOW, SMALL
	1			11	D2942	REPLACEMENT WINDOW, LARGE
		1		- #	D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1				-:-	D2126-0600	SEAL
	1			- ;; -	D2463-0750	NEOPRENE SEAL
	<u> </u>	1		1	D2463-0860	NEOPRENE SEAL
	9	12	<u> </u>	11	2600-6	1/4 TURN FASTENER
	9	12			2600-U	WASHER
	9	12		11	212-12	RECEPTACLE
	22	21		11	AN526C832R9	SCREW (OR AN526C832-9.OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21		11	MS21042L08	NUT (OR MS21042-08)
	18	24		1 \	MS20426AD3-5	RIVET
2 SQ.	2 SQ.	2 SQ.		1 1	N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
YD YD	Z SQ. YD	YD		V	N/A	5.702 7701 G GLAGS CHIVERSAL WEAVE
10	10	10				
					D2463-0450	NEOPRENE SEAL
				7-1-2	D3210-1 —	DOUBLER
				7 1	D3211-1 🗲	BRACKET
			·	7 1	D3212-1 5	FLOOR WINDOW
				7_1	-D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
		-	1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
		·	9	4_8_	AN526C632R12	*SCREW-(OR AN526C632-12, OR MS51957-32)
		·	9	/8	AN960JD6 7	WASHER
			9	7 8	MS21042L06	NUT (OR MS21042-06)
			2	1 40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	_ 20	MS20470AD4-7	
		L	10	13 20	1 HIOZOTI OND4-1 ,	1117E-1

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Revision: **D**

Date: 08.07.08